

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014530**Date Inspected:** 06-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG		

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 8CW

ABF Report No: UT-8W-041

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between deck panel and edge panel of OBG segment 8CW (Cross beam side). The weld designations are as follows.

SEG047\*-043 (OBG 8CW-D.P to E.P, Cross beam side)

ULTRASONIC INSPECTION

OBG SEGMENT 8AW

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ABF Report No: UT-8W-039

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between deck panel and edge panel of OBG segment 8AW (Cross beam side). The weld designations are as follows.

SEG043\*-044 (OBG 8AW-D.P to E.P, Cross beam side)

OBG SEGMENT 8BW

ABF Report No: UT-8W-040

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between deck panel and edge panel of OBG segment 8BW (Cross beam side). The weld designations are as follows.

SEG050-002, 006 (OBG 8BW-D.P to E.P, Cross beam side)

OBG SEGMENT 8BW-8CW

ABF Report No: UT-8W-037

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the edge panel splice weld between of OBG segment 8BW-8CW (Cross beam side). The weld designations are as follows.

OBW8A-005 (OBG 8BW-8CW, E.P to E.P, Cross beam side)

CROSS BEAM # 08

ABF Report No: UT-CB8-005

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between deck panel to side panel (west side) of cross beam # 08. The weld designations are as follows.

CB202A-008-013, 015 (C.B#08, D.P to S.P, West side)

CROSS BEAM # 08

ABF Report No: UT-CB8-004

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between deck panel to side panel (east side) of cross beam # 08. The weld designations are as follows.

CB202A-008-01, 003 (C.B#08, D.P to S.P, east side)

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### CROSS BEAM # 08

ABF Report No: UT-CB8-006

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between bottom panel to side panel (East side) of cross beam # 08. The weld designations are as follows.

CB202A-008-004, 006 (C.B#08, B.P to S.P, east side)

### CROSS BEAM # 08

ABF Report No: UT-CB8-007

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between bottom panel to side panel (West side) of cross beam # 08. The weld designations are as follows.

CB202A-008-018, 016 (C.B#08, B.P to S.P, West side)

### OBG SEGMENT 7DW-7EW

ABF Request: 06062010-2

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the side panel splice weld between OBG segment 7DW and 7EW (Counter weight side). Inspection was carried out on repair areas. The weld designations are as follows.

OBW7C-006, 007 (OBG 7DW-7EW- S.P, Counter weight side)

### OBG SEGMENT 7DE

ABF Request: 06042010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Bike path side) of OBG segment 7DE. Inspection was carried out on repair areas. The weld designations are as follows.

CA042-002 (OBG 7DE- D.P to E.P, Bike path side)

### MAGNETIC PARTICLE INSPECTION

#### OBG SEGMENT 7DW-7EW

ABF Request: 06062010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the side panel splice weld between OBG segment 7DW and 7EW (Counter weight side). Inspection was carried out on repair areas.

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Weld identification number was.

OBW7C-006, 007 (OBG 7DW-7EW- S.P, Counter weight side)

No relevant indications were observed.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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